



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3009-3**Job Sheet 187521****Part No:** D3009-3**Job Qty:** 60 pcs**Part Name:** Cup**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 12/6/18**Job Tracking No:****Due Date:** 12/17/18**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP A 07.12.18 new issue EC IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	12/17/18	12/17/18	0.00	0.00	Start Up Machining-1		JBD 12/12/21
100	Hardinge - 1	60 pcs	12/17/18	12/17/18	0.00	7.10	Hardinge		
							Hardinge - 1		JBD 12/12/21
120	QC 8	60 pcs	12/17/18	12/17/18	0.00	0.00	QC8		
130	Packaging 3-1 - Stock - B4B	60 pcs	12/17/18	12/17/18	0.00	0.00	Packaging3-1		DAG 21 DEC 21 2018
140	QC 21 - SA	60 pcs	12/17/18	12/17/18	0.00	0.00	QC21		

Part Op 100 - (Hardinge)1-TURN AS PER FOLIO FA130 & DWG D3009

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location:)*****STOCK IN LARGE FAB***** LOCATION WA002

140 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	2.8740 ft (.0479 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	3	36	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Cup	0.750Inches + 0.008 - 0.001	0.758 0.749	Diameter	
3	Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
4	Cup	0.062Inches ± 0.010	0.072 0.052	Radius	
5	Cup	0.094Inches ± 0.010	0.104 0.084		
6	Cup	0.353Inches ± 0.010	0.363 0.343		
7	Cup	0.063Inches ± 0.010	0.073 0.053		
8	Cup	0.032Inches ± 0.010	0.042 0.022	Radius	
9	Cup	45.000Degrees ± 0.000	45.000 45.000	Angle	

Plex 12/21/18 8:41 AM Dart.Gagnon.Michelle



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D3009-3

Job Sheet 187521



Part No: D3009-3

Job Qty: 60 ea

Part Name: Cup



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/6/18

Job Tracking No:

Due Date: 12/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 07.12.18 new issue EC IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		12/17/18	0.00	0.00	Start Up Machining-1	11/8	SBD 16/12/21
100	Hardinge	60 pcs		12/17/18	0.00	7.10	Hardinge	11/8	" 18/12/21
120	QC	60 pcs		12/17/18	0.00	0.00	QC8		
130	Packaging	60 pcs		12/17/18	0.00	0.00	Packaging3-1		
140	QC21-SA	60 Ea		12/17/18	0.00	0.00	QC21		

Part Op 100 - 1-TURN AS PER FOLIO FA130 & DWG D3009

Descriptions: 130 - *****STOCK IN LARGE FAB***** LOCATION WA002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	2.8740 ft (.0479 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	3	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Cup	0.750Inches + 0.008 - 0.001	0.758 0.749	Diameter	
3	Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
4	Cup	0.062Inches ± 0.010	0.072 0.052	Radius	
5	Cup	0.094Inches ± 0.010	0.104 0.084		
6	Cup	0.353Inches ± 0.010	0.363 0.343		
7	Cup	0.063Inches ± 0.010	0.073 0.053		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

8	Cup	0.032Inches ± 0.010	0.042 0.022	Radius
9	Cup	45.000Degrees ± 0.000	45.000 45.000	Angle

Plex 12/6/18 12:47 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐													
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)											
Description Work Order Deviation				Disposition													
				Completed By													
				Lead hand / Supervisor													
				QC / QA Coordinator													
				FAULT CATEGORY													
				<table border="0"><tr><td>☐ Power Loss/Surge</td><td>☐ Positioned Wrong</td></tr><tr><td>☐ Folio/Program</td><td>☐ Outside Tolerance</td></tr><tr><td>☐ Grain Direction</td><td>☐ Drawing</td></tr><tr><td>☐ Weld</td><td>☐ Finish</td></tr><tr><td>☐ Wrong Stock Pulled</td><td>☐ Part Lost/Missing</td></tr><tr><td>☐ Out of Sequence</td><td>☐ Misread</td></tr><tr><td>☐ Off-set/Set-up</td><td></td></tr></table>				☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Tolerance	☐ Grain Direction	☐ Drawing	☐ Weld	☐ Finish	☐ Wrong Stock Pulled	☐ Part Lost/Missing
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☐ Off-set/Set-up																	

Part: D3009-3
Job No: 187521
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: Various STC's

Date: 12/21/18

